

79509

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 26/01/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 09/02/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

100		0.00		
100	HAAS CNC VERTICAL MACHINING #1			
HAAS I	Memo	0.00	RR 12.3.21	4 10
HAAS CNC vertical machine #1	1- Program batch number2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached			
110		0.00		
110	CONVENTIONAL MILLING MACHINE			
Mill Conv	Memo	0.00	RR 12.3.21	4 10
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet			
120		0.00		
120	QC2- Inspect parts off machine FAI/FAIB			
QC	Memo	0.00	RR 12.3.21	4 10
Quality Control				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79509

79509

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January-26-12 4:05:10 PM

Item ID: D2665-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH Fwd Aft Out 206
 Start Date: 26/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>OK 12/03/22</i>			<i>1/</i>	<i>0</i>		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>4</i>	<i>0</i>	<i>DP</i>	<i>12/03/22.</i>
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>3h35</i> <i>4h05</i> FINISH TIME:	0.00 0.00				<i>4</i>	<i>0</i>	<i>DP</i>	<i>12/03/22.</i>
		OVEN TEMPERATURE: <i>320°F</i>		<i>m120222</i>					

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 79509

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Page 3

January-26-12 4:05:10 PM

Item ID: D2665-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, RH Fwd Aft Out 206
 Start Date: 26/01/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							4X/ M-L 12/03/23
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>136</u> Memo	0.00 0.00							13/26 (40f)
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ 12/03/27 MLJ 12/03/27 (4)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

January-26-12 4:05:14 PM

Page 1

Work Order ID: 79509

79509

Parent Item: D2665-2

D2665-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C 00.11.01 Removed P/O for Powder Coat - in house process
EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No			100	Each	120.0000	1	4			
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D6101-003

**

Saddle Billet, 7075

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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MAT040	126	
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73775	2	
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73780	7	
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78159	54	
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78599	56	
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MAT042	-7	
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MAT044	1	
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73769	1	
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80765	.	
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4 F.K 12/03/19.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 79509
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140	OK. 02	.125	.125	.125	.125		
B	0.100	0.140		.122	.122	.122	.122		
C	1.125	1.145		1.136	1.136	1.136	1.136		
D	0.615	0.685		.680	.680	.680	.680		
E	0.240	0.260		.255	.255	.255	.255		
F	1.313	1.343		1.329	1.329	1.329	1.329		
G	0.210	0.230		.225	.225	.225	.225		
H	0.100	0.180		.130	.130	.130	.130		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.576	1.576	1.576	1.576		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.004	1.004	1.004	1.004		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		6.002	6.002	6.002	6.002		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.793	.793	.793	.793		
W	0.540	0.560		.548	.548	.548	.548		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.922	.922	.922	.922		
AA	0.490	0.510		.503	.503	.503	.503		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>RP</i>	Audited by: <i>AM</i>
Date: 12.3.21	Date: 12/03/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

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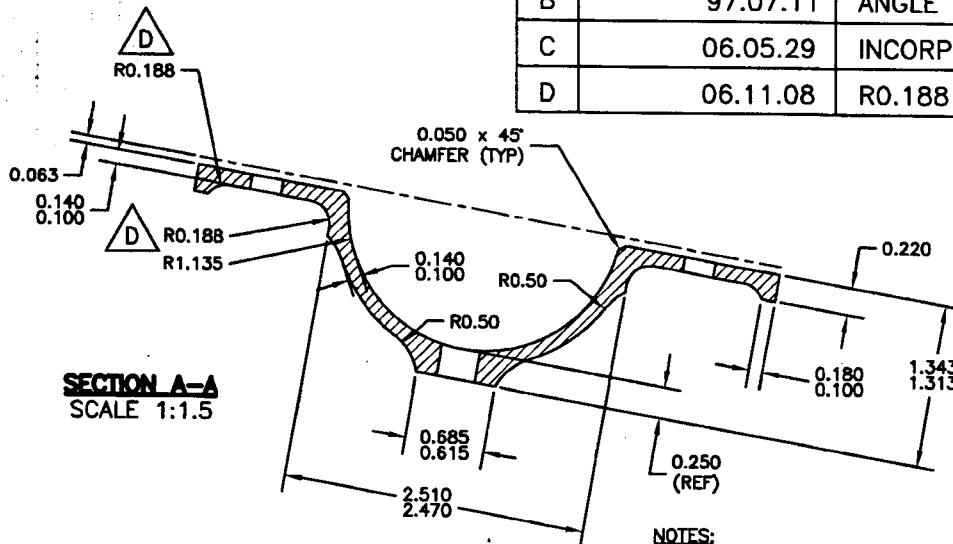
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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



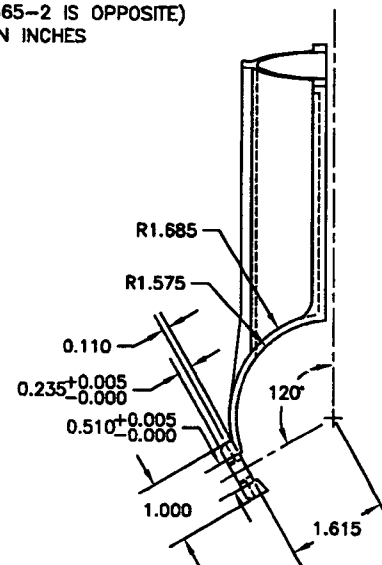
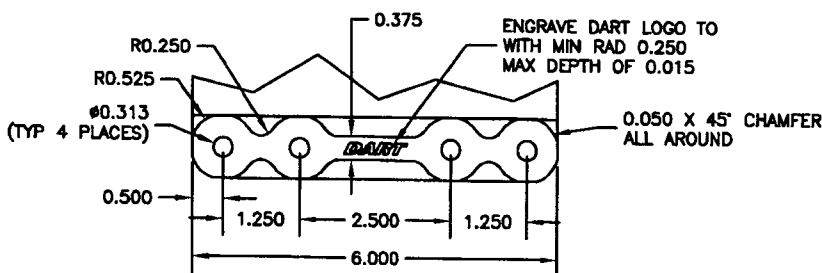
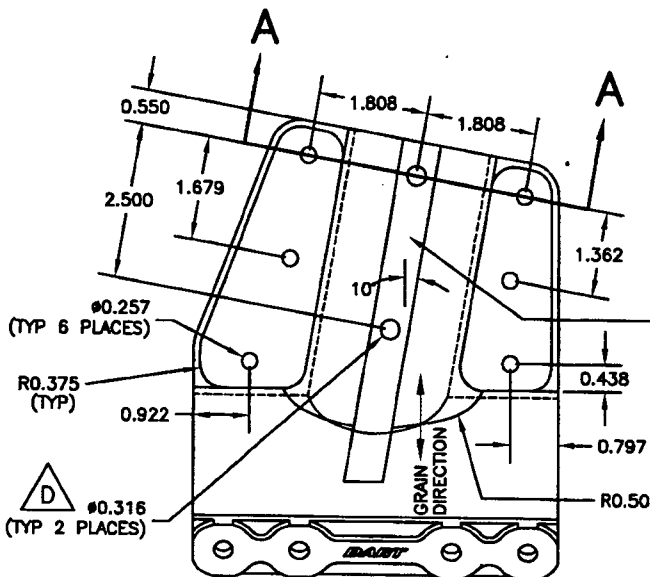
RELEASED

07.02.12

SHOWN
REFERENCE
ENGINEERING
UNCONTROLLED COPY
SUBMITTAL
NO. 79509

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2665-1 SADDLE FWD OUTSIDE HIGH

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